

Work Order ID 73843



Page 1

Friday, September 16, 2011 12:35:53 PM

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

B.A. 11/11/24

10

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
by B.A. 11/11/24 ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

B.A. 11/11/24

10

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

F.K. 11/11/26

120

0.00



QC2- Inspect parts off machine FAI/FAIB

B.A. 11/11/24

10

QC

Memo

0.00

Quality Control

F.K. 11/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73843

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M118434

320°F

9:15

9:45

10X4M-11/11/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73843

Friday, September 16, 2011 12:35:53 PM



Page 3

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10	11-11-29		
170 Packaging Packaging	Identify as per dwg & Stock Location: 435 Memo	0.00 0.00				11/11/30		100	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/11/30 MF 11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:35:50 PM

Page 1

Work Order ID: 73843



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C000.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003

Manufactured

No

100

Each

13.0000

1

10



Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

5

72226

5

74680

<

10

10

FK 11/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 73843
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.132	0.133	0.132	0.132		0.132
B	0.100	0.140		0.125	0.125	0.125	0.125		0.125
C	1.125	1.145		1.135	1.1353	1.1351	1.135		1.135
D	0.615	0.685		0.675	0.675	0.675	0.675		0.675
E	0.240	0.260		0.253	0.253	0.253	0.253		0.253
F	1.313	1.343		1.326	1.326	1.326	1.326		1.326
G	0.210	0.230		0.227	0.227	0.227	0.227		0.227
H	0.100	0.180		0.135	0.135	0.135	0.135		0.135
I	2.470	2.510		2.490	2.490	2.490	2.490		2.490
J	1.565	1.585		1.575	1.5745	1.5749	1.5745		1.575
K	0.235	0.240		0.238	.237	.236	.237		.237
L	0.100	0.120		0.111	.110	.109	.110		.110
M	0.990	1.010		1.000	1.000	1.000	1.000		1.000
N	0.510	0.515		0.512	.512	.512	.512		.512
O	5.990	6.010		6.000	6.000	6.000	6.000		6.000
P	1.245	1.255		1.250	1.250	1.250	1.250		1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500		2.500
R	0.313	0.318		0.314	0.314	0.314	0.314		0.314
S	0.315	0.322		0.316	0.316	0.316	0.316		0.316
T	2.495	2.505		2.500	2.500	2.500	2.500		2.500
U	1.357	1.367		1.362	1.362	1.362	1.362		1.362
V	0.787	0.807		0.797	0.797	0.797	0.797		0.796
W	0.540	0.560		0.550	0.550	0.550	0.550		0.550
X	1.674	1.684		1.679	1.679	1.679	1.679		1.679
Y	0.257	0.262		0.260	0.260	0.260	0.260		0.260
Z	0.912	0.932		0.923	0.922	0.922	0.922		0.923
AA	0.490	0.510		0.497	0.500	0.500	0.500		0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188		0.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	B.A. / K.K.
Date:	11/11/24 / 11/11/26

Audited by:	OMK
Date:	11/11/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	

DART AEROSPACE LTD	Work Order: 73843
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

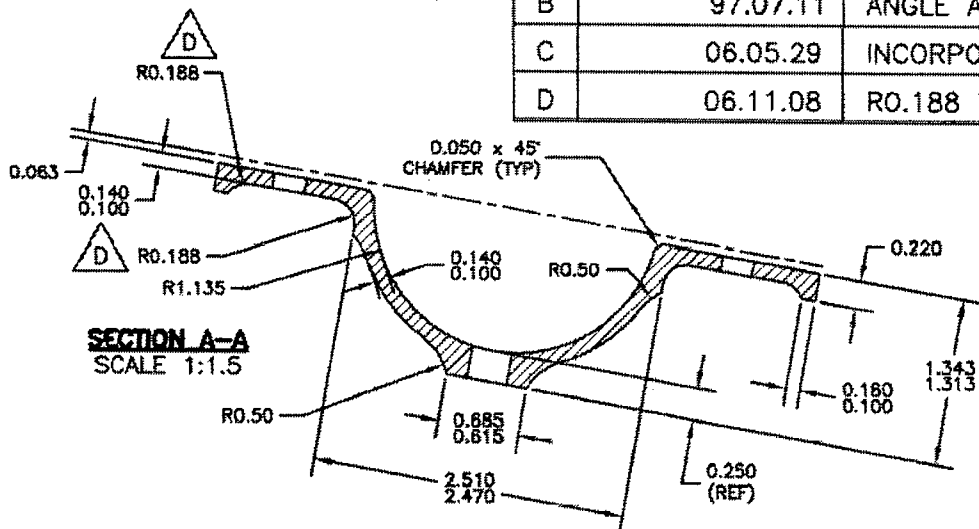
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				16	17	18	19		
A	0.100	0.140		0.132	0.133	0.132	0.131		0.132
B	0.100	0.140		0.125	0.125	0.125	0.125		0.125
C	1.125	1.145		1.1345	1.1356	1.1352	1.1351		1.1355
D	0.615	0.685		0.675	0.675	0.675	0.675		0.675
E	0.240	0.260		0.253	0.253	0.253	0.253		0.253
F	1.313	1.343		1.326	1.326	1.326	1.326		1.326
G	0.210	0.230		0.227	0.227	0.227	0.227		0.227
H	0.100	0.180		0.135	0.135	0.135	0.135		0.135
I	2.470	2.510		2.490	2.490	2.490	2.490		2.490
J	1.565	1.585		1.5742	1.575	1.575	1.575		1.5752
K	0.235	0.240		.237	.237	.237	.237		.237
L	0.100	0.120		.110	.110	.110	.110		.110
M	0.990	1.010		1.000	1.000	1.000	1.000		1.000
N	0.510	0.515		.512	.5102	.5102	.512		.512
O	5.990	6.010		6.000	6.000	6.000	6.000		6.000
P	1.245	1.255		1.250	1.250	1.250	1.250		1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500		2.500
R	0.313	0.318		0.314	0.314	0.314	0.314		0.314
S	0.315	0.322		0.316	0.316	0.316	0.316		0.316
T	2.495	2.505		2.500	2.500	2.500	2.500		2.500
U	1.357	1.367		1.362	1.362	1.362	1.362		1.362
V	0.787	0.807		0.797	0.797	0.797	0.797		0.797
W	0.540	0.560		0.550	0.550	0.550	0.550		0.550
X	1.674	1.684		1.679	1.679	1.679	1.679		1.679
Y	0.257	0.262		0.260	0.260	0.260	0.260		0.260
Z	0.912	0.932		0.923	0.923	0.923	0.923		0.923
AA	0.490	0.510		0.500	0.500	0.500	0.500		0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188		0.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>K.A. / FK</u>	Audited by: <u>md</u>
Date: <u>11/11/24</u> / <u>11/11/20</u>	Date: <u>11/11/26</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	<u>NA</u>



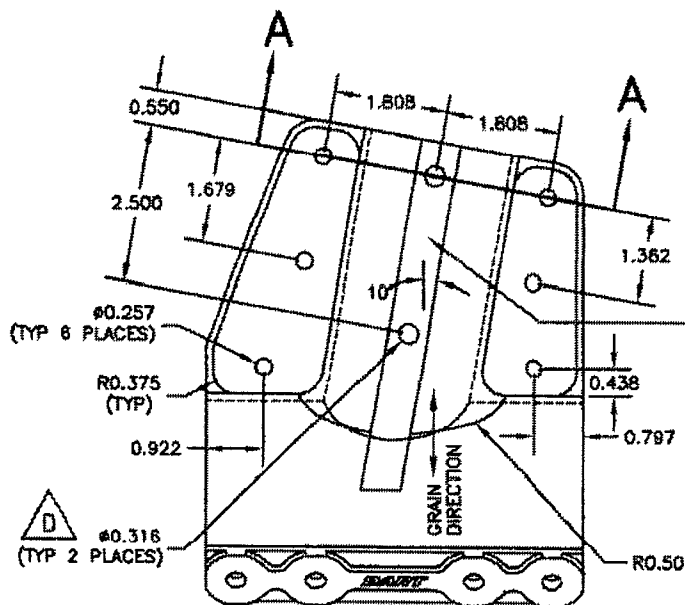
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



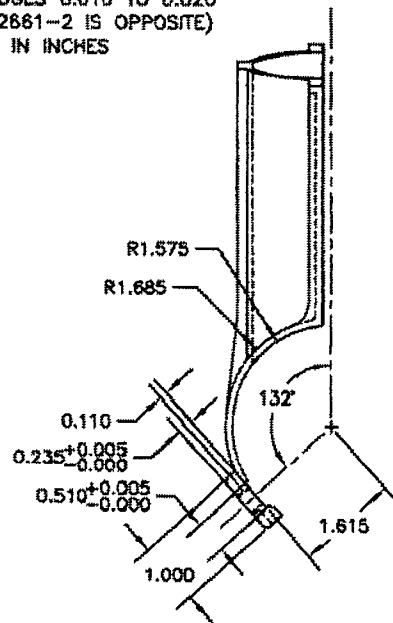
RELEASED
07.02.12 **#**

NOTES:

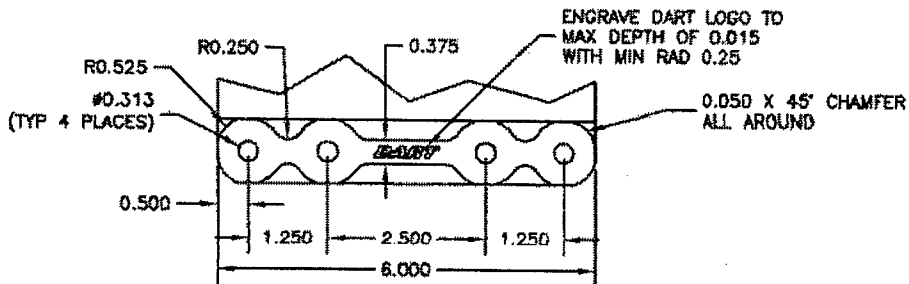
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2661-1 SADDLE OUTSIDE



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